

Work Order ID 70571

Monday, June 13, 2011 10:22:49 AM



Page 1

Item ID: D3914-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Lid Assembly (350)

Start Date: 6/10/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date: *11-06-13*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3914

B

100

Weld per dwg A/R S.S. rod Batch: *115928* 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D3914 using DT9607A

2- weld hinge (3) and Mounting brackets as per dwg D3914

inspect before welding mesh

3- tack weld mesh on basket as per dwg D3914

make sure to place mesh correctly on lid, check with label plate before tacking mesh

Cpl 11-06-30

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

11-06-30 1 0 BE11/06/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Required Date:	6/22/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00							
			J Mo 7/04						
130 Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 Memo *** mask sides of hinge prior to powdercoat*** Start Time: 8-20 Oven Temperature: 3200F Finish Time: 8-50	0.00 0.00							
			LX 4 M-L 11/07/04						
140 HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch Memo 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install placard and label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***	0.00 0.00							
			1 BL 11-7-4 ES 11/07/05						

M 11 5128

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Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00							<i>EP 11/07/05</i>
160 	Identify as per dwg & Stock Location: <i>G-A</i>	0.00							
Packaging Packaging	Memo <i>w/b 70569</i>	0.00							<i>EP 11/07/05</i>
170 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							<i>11/7/5 JF</i> <i>MF</i> <i>11-07-05</i>

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Picklist Print

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Page 1

Work Order ID: 70571

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
as per dwg revB DD 10.08.18 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2581		Manufactured	No			100	Each	74.0000	2	2			
-------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--



Mounting Bracket

Location

Loc Qty

Loc Code

WA

74

68964

6

69258

28

69739

40

D3914-1

Manufactured No

100

Each

8.0000

2



Rib

Location

Loc Qty

Loc Code

WA006

8

69063

4

69520

4

D3914-7

Manufactured No

100

Each

8.0000

2



Rib

Location

Loc Qty

Loc Code

WA

4

70335

4

WA006

4

69729

4



SAD 11-06-25



SAD 11-06-25



SAD 11-06-25

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Page 2

Work Order ID: 70571

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 1.00

Required Qty: 1.00

D4016-3 Manufactured No 100 Each 7.0000 3 3
Hinge Half, Lid

Location Loc Qty Loc Code

WA 69164

7 7



SAD 11-06-25

D4018-5 Manufactured No 100 Each 19.0000 9 9
Rib

Location Loc Qty Loc Code

WA005 67041 69726

19 14 5
B70 337



SAD 11-06-25

D4020-5 Manufactured No 100 Each 1.0000 1 1
Mesh (350 Basket Long, Lid)

Location Loc Qty Loc Code

WA 68234

1 1



B69162 -> ①

D4021-3 Manufactured No 100 Each 1.0000 1 1
Data Plate

Location Loc Qty Loc Code

WA 69724

1 1



SAD 11-06-25

D4035-041 Manufactured No 100 Each 0.0000 1 1
Lid Rib Assembly, Fwd (350 Basket)

B69727



SAD 11-06-25

①

Monday, June 13, 2011 10:22:55 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Page 3

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Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 1.00

Required Qty: 1.00

D4035-043

Manufactured No

100

Each

2.0000

1

1



Lid Rib Assembly, Aft (350 Basket)

Location

Loc Qty

Loc Code

WA006

2

67375

2

140

Each

0.0000

1

1

D2728-3

Manufactured No



Dart Logo label



Pl 11.06.30

B69869 → ①

4/11/07/05

Monday, June 13, 2011 10:22:55 AM

Shop Packet Print

Page 3

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W/O:		WORK ORDER CHANGES					
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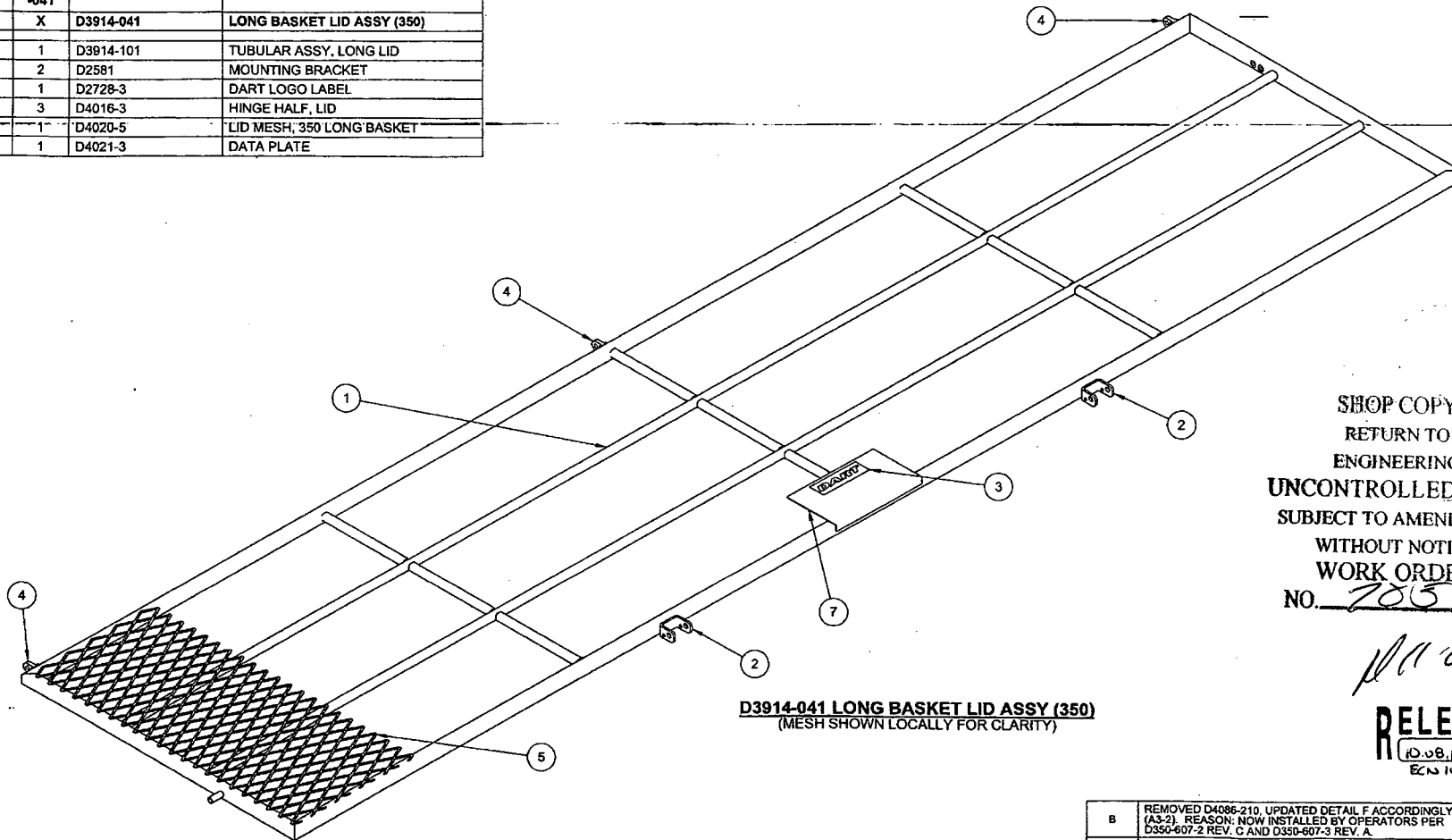
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ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70571

11/06/13

RELEASED
10.08.17
ECN 10-596

B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	SC	D3914	SHEET 1 OF 4
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	LONG BASKET LID ASSY (350)	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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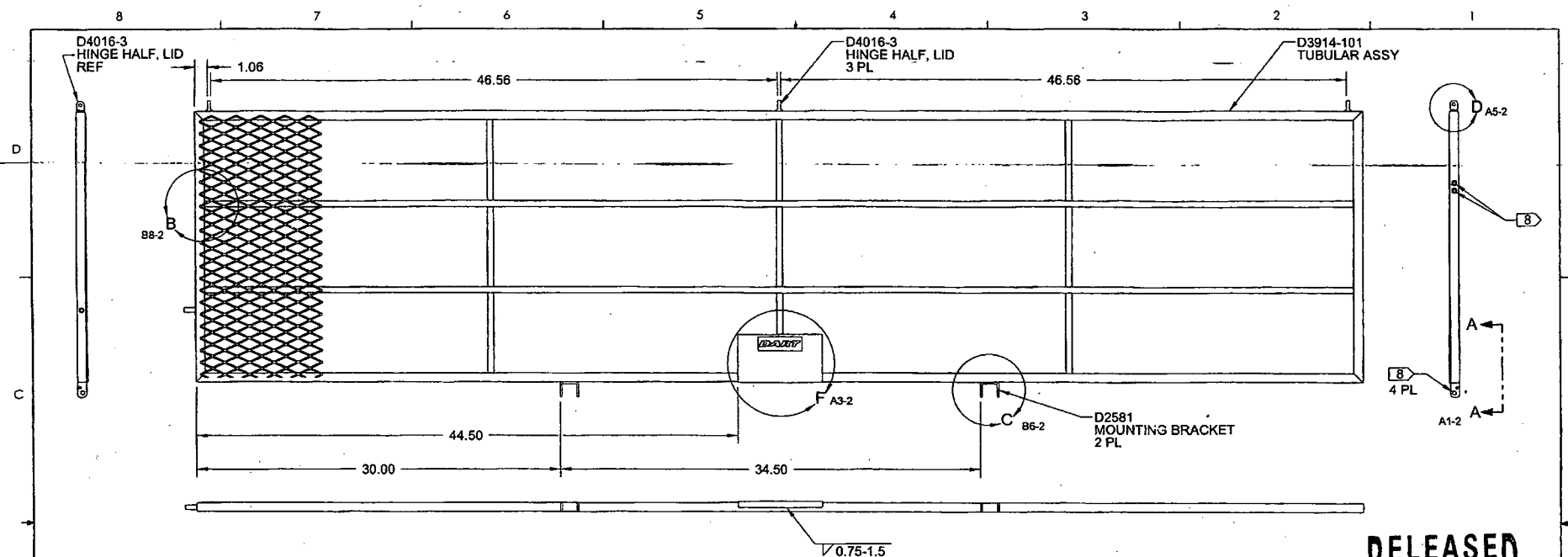
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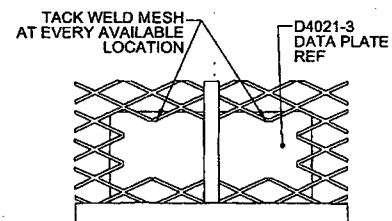
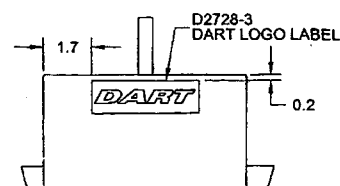
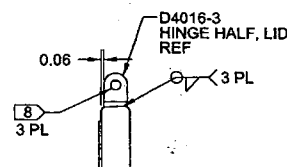
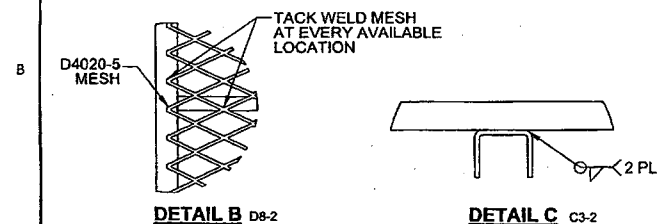
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NOTE: Date & initial all entries



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10-08-12 UP



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

also 70571

DESIGN	A15	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	WJ	D3914	SHEET 2 OF 4
APPROVED	WJ	TITLE	SCALE
DE APPR.	WJ	LONG BASKET LID ASSY (350)	
DATE	10.08.05	NTS	
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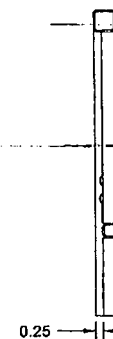
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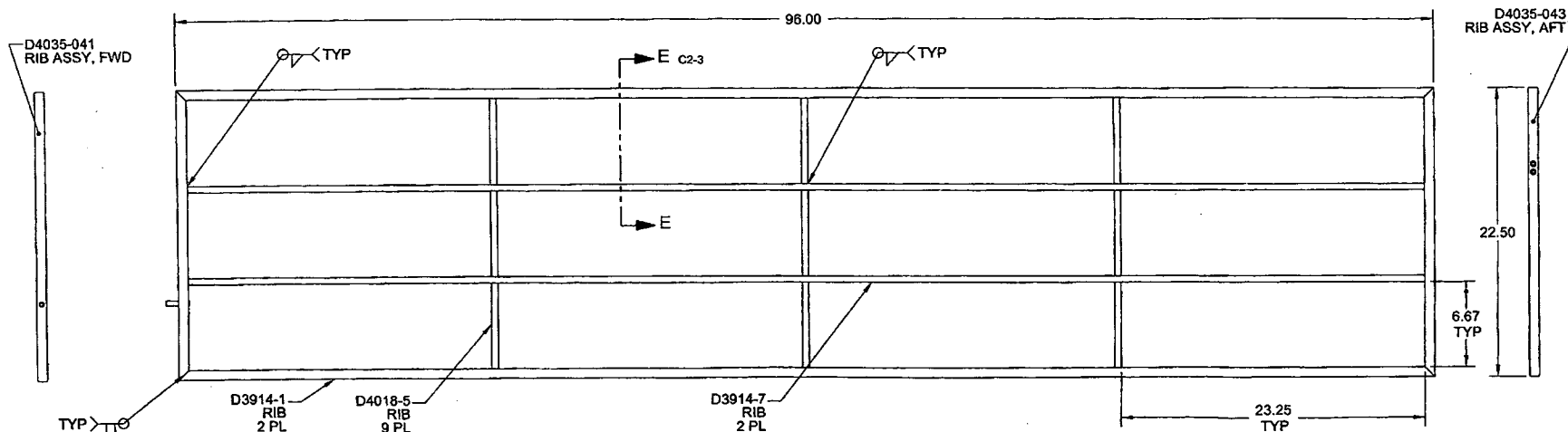
NOTE: Date & initial all entries

ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3

W/0 7054



8 D3914-101 TUBULAR ASSY, LONG LID

RELEASED
10-08-12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

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CHECKED	TC	DRAWING NO.	REV. B
MFG. APPR.	MP	D3914	SHEET 3 OF 4
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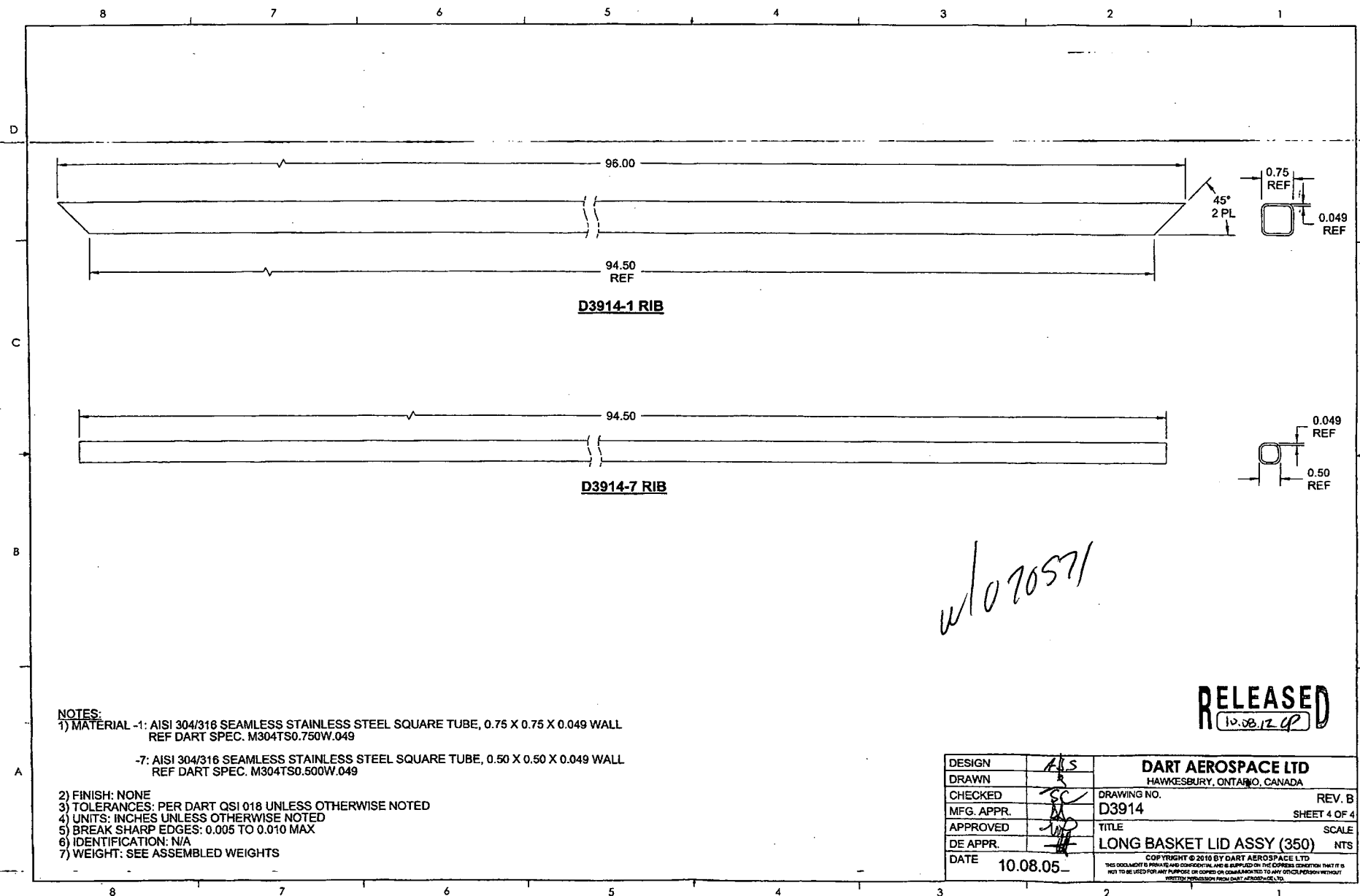
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NOTES:

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

RELEASED
10.08.12 GP

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DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
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